

Date: Thursday, 3/30/2006 10:05:11 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y
Job Number	: 26442		
Estimate Number	: 10360		
P.O. Number	: N/A	Part Number	: D2350
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D2350 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE ABOVE USER DATE</u>	Due Date	: 4/6/2006 Qty: 5 Um: Each
Checked & Approved By	: <u>06.03.30</u>		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6201	T Extrusion 4X4X3/8
-----	-------	---------------------



Comment: Qty.: 1.0631 f(s)/Unit Total: 5.3156 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch:

B19492ml 06/04/025

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 12.150" long

ml 06/04/025

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

En 06/04/035

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE.
-----	-----	-----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/04/035

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 06-04-035

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1


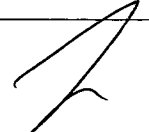
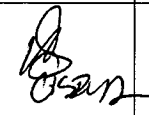

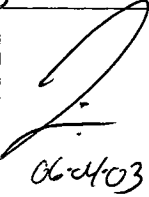
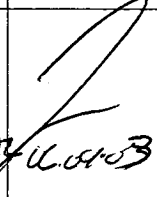
Tumble &amp; deburr

En 06/04/035

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2350 PAR #: N/A Fault Category: Red / PAR. ASS <sup>med & small</sup> NCR: Yes No DQA: Yes Date: 06/04/10  
 QA: N/C Closed: Yes Date: 06.04.10

NCR: <u>26442</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/03	3	two holes at the wrong place. <del>was</del> the origins off of two inches.		Scrap & destroy replace.	En 06/04/03	 06-04-03		 06-04-03
06/04/03	3	1.700 dimension ending is 1.671/1.674/1.671/1.675 (see attached enc.1) * Part 1: 1.671/1.674, Part 2: 1.671/1.675	CP 06.04.03	PARTS are OK per DS email	EP 06/04/03	 06-04-03	CP 06.03.04 per DS email	 06-04-03

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:05:11 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26442

Part Number: D2350

Job Number:



Seq. #: Machine Or Operation: Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.L 06.04.03 5

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M

06-04-04

(5)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M

06-04-04

(5)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06/04/05

(5)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372

Fastener

B19507

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444

Pip Pin

B25811  
B25824

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L

Washer

M18235

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/30/2006 10:05:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26442

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M18917

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw M13719

SB 06/04/06 (5)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-04-06 (5)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57171

06/4/7 (5)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/10 (5)

Job Completion



06-04-07

F15.1

Assemble as per Dwg D2350

SB 06/04/06 (5)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED  
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>X</i> 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

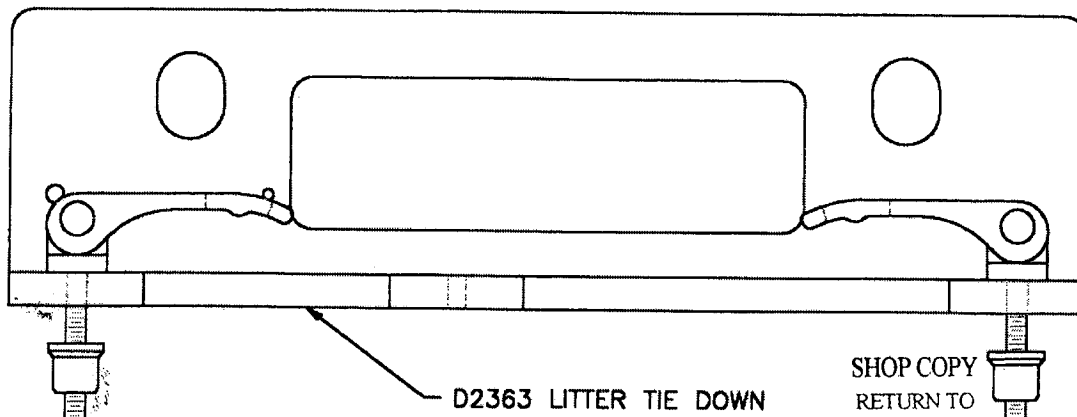
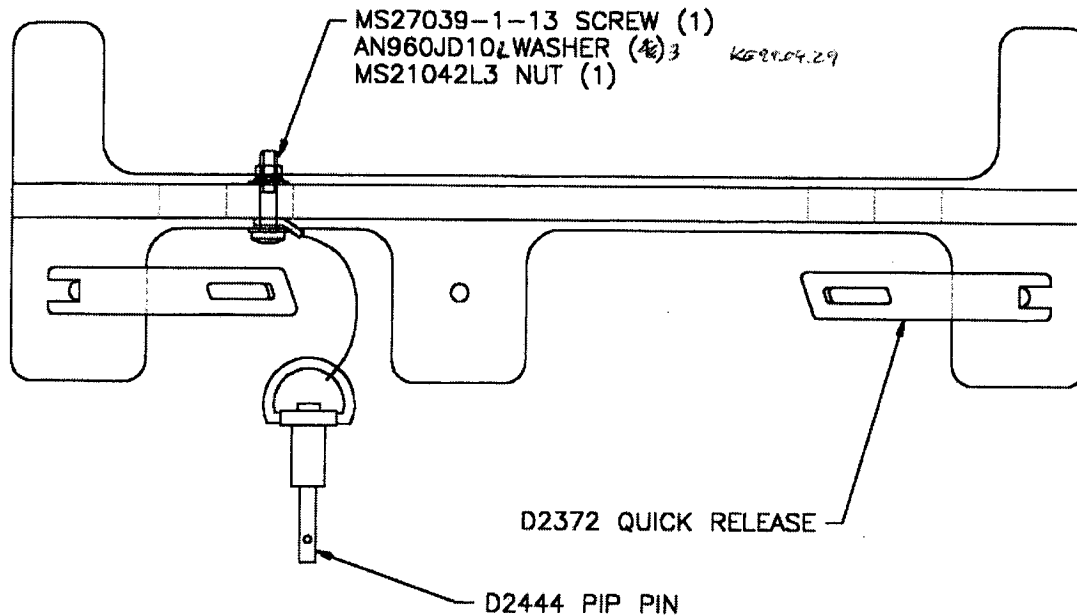
KE 99.04.29

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26442



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED	D2350	SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED  
960607



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

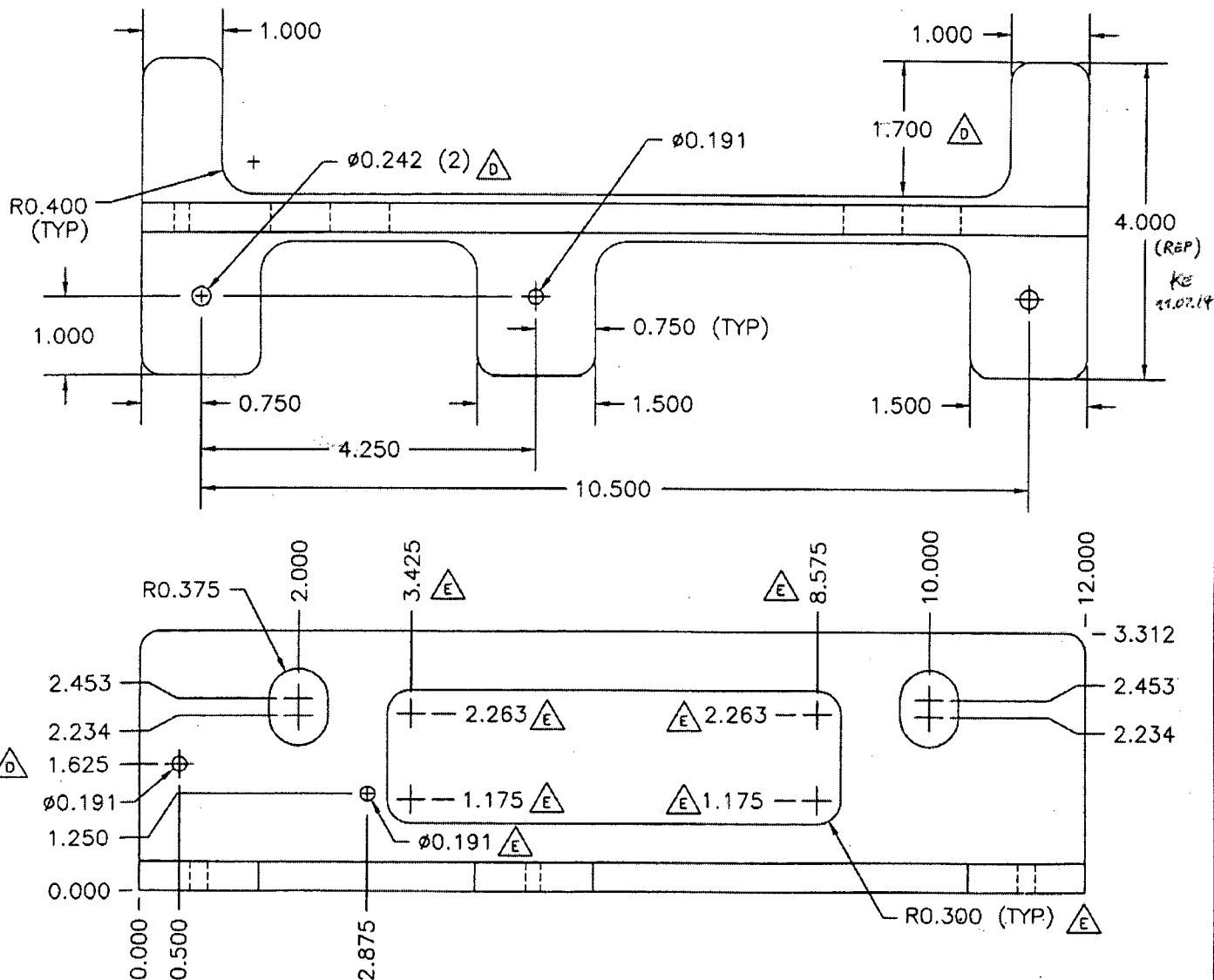
NO. 26442





DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIOX	APPROVED BW	DRAWING NO. D2363	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED  
971003 KE  
TSR 4129



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION  
FINISH: ANODIZE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

Copyright 1995 by DART AEROSPACE LTD

WITHOUT NOTICE  
WORK ORDER  
NO. 26442

1675

## Chris Provencal

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** April 3, 2006 11:39 AM  
**To:** Chris Provencal  
**Cc:** Linda Lacelle  
**Subject:** Fw: NCR D2363 tie down



tie\_down.jpg

Chris,

This is an acceptable deviation.

David

----- Original Message -----

**From:** "Chris Provencal" <cprovencal@dartaero.com>  
**To:** <davids@dartaero.com>  
**Sent:** Monday, April 03, 2006 8:39 AM  
**Subject:** NCR D2363 tie down

> Dave,  
>  
> D2363 tie down. The dimension 1.700 on dwg D2363 Rev.E is 1.671, 1.674,  
> 1.671, and 1.675 for each of the four quadrants. The total width is  
3.980,  
> which on the dwg is listed as 4.000(ref). There is only qty(1) affected  
by  
> this.  
>  
> Sincerely,  
> Chris Provencal  
> DART Aerospace Ltd.  
> Email..cprovencal@dartaero.com  
> Phone...613-632-3336  
> Fax.....613-632-4443  
>  
>

\* 2 parts affected P060403

DART AEROSPACE LTD		Work Order:	26442
Description: <i>Litter Tie Down Ass'y</i>		Part Number:	D2350
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+ 0.000	0.999	✓			
1.000	± 0.010	0.999	✓			
1.700	± 0.010	1.697	✓			
4.000	± 0.010	3.998	✓			
1.500	± 0.010	1.501	✓			
10.500	± 0.010	10.498	✓			
0.750	± 0.010	0.753	✓			
1.500	± 0.010	1.501	✓			
4.250	± 0.010	4.244	✓			
0.750	± 0.010	0.750	✓			
1.000	± 0.010	1.001	✓			
Ø 0.242	± 0.005	0.243	✓			
Ø 0.191	± 0.005	0.192	✓			
0.500	± 0.010	0.503	✓			
2.875	± 0.010	2.877	✓			
Ø 0.191	± 0.005	0.191	✓			
1.250	± 0.010	1.245	✓			
Ø 0.191	± 0.005	0.191	✓			
1.625	± 0.010	1.620	✓			
2.000	± 0.010	1.997	✓			
10.000	± 0.010	9.997	✓			
12.000	± 0.010	12.002	✓			

Measured by: <i>En</i>	Audited by: <i>J.L</i>	Prototype Approval:
Date: <i>06/04/03</i>	Date: <i>06.04.03</i>	Date: <i>1</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

# FIRST ARTICLE INSPECTION CHECKLIST

## Prototype

